

Work Order ID 74724

Wednesday, October 05, 2011 1:59:09 PM



Page 1

Item ID: D3262-5

Accept



Setup Start



Revision ID:

Item Name: Cap

Stop



Start Date: 10/5/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan: M.L.J

Date: 11/10/05

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3262

E

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 6.000" x 0.500" x 5.400" long Bar

11-10-06

5

0

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

HAAS CNC vertical machine #1

Memo

0.00

Machine as per dwg D3262
Machine as per Folio FA902 and Dwg D3262
FOLIO REV: 1A
DWG REV: E
TAP USING JIG DT9636
Deburr

11.10.12

5

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74724

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Page 2

Item ID: D3262-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Cap

Start Date: 10/5/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

20 10-10-12

5

0

130 QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

B.A 11/10/12

5

0

140 Identify as per dwg & Stock Location: LC

0.00



Packaging

Memo

0.00

Packaging

5 Sp 11-10-13.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 74724

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Page 3

Item ID: D3262-5

Accept

Setup Start

Revision ID:

Stop

Item Name: Cap

Start Date: 10/5/2011 Start Qty: 5.00

Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 5.00

Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/13

CMF 11-10-13

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Picklist Print

Wednesday, October 05, 2011 1:59:25 PM

Page 1

Work Order ID: 74724

Parent Item: D3262-5

Parent Item Name: Cap



Start Date: 10/5/2011

Required Date: 10/14/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A NEW ISSUE 10-01-19 JLM VERIFIED BY:EC IPP
Rev:B as per ECN10-571 DD 10.05.10 verified :EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X06.00 0		Purchased	No			100	f	30.2500	0.96	5.052632			



SL 11-10-05

6061-T6 Bar .500 x 6.00

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT004	30.25	
112567	14.25	
115045	16	

5.1

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 74724
Description: Cap		Part Number: D3262-5
Inspection Dwg: D3262	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.45	+/-0.030	.432	/		2P.02	
0.25	+/-0.030	.248	/		2P.02	
Ø0.875	+/-0.010	.875	/			
Ø5.005	+0.010/-0.000	5.005	/			
R0.063	+/-0.010	.063	/			
0.080	+/-0.010	.082	/			
0.13	+/-0.030	.128	/			
0.070 x 45°	+/-0.010 x 0.5°	.075	/			
Ø5.165 Ref	+/-0.010	5.167	/			
1.63	+/-0.030	1.63	/			
3.25 Ref	+/-0.030	3.246	/			
9/16-18 UNF-3B	N/A	"	/			
3/4-16 UNF-3B	N/A	"	/			
0.091	+0.007/-0.008	.092	/			
R0.03	+/-0.010	R.03	/			
R0.02	+0.00/-0.01	R.01	/			
45°	+/-0.5°	45°	/			
30°	+/-0.5°	30°	/			
Ø0.588	+0.005/-0.000	.589	/			
Ø0.696	+0.007/-0.008	.690	/			
0.101	+0.008/-0.007	.103	/			
R0.03	+/-0.010	R.03	/			
R0.02	+0.00/-0.01	R.01	/			
45°	+/-0.5°	45°	/			
30°	+/-0.5°	30°	/			
Ø0.771	+0.005/-0.000	.772	/			
Ø0.882	+0.008/-0.007	.875	/		"	

Measured by: RP	Audited by: B.A	Preliminary Approval:
Date: 11.10.12	Date: 11/10/12	Date:

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ	

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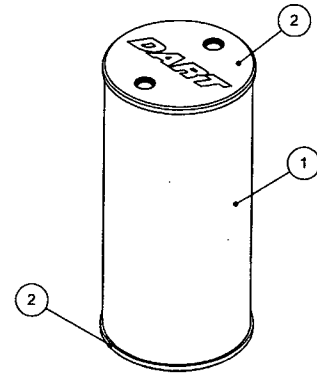
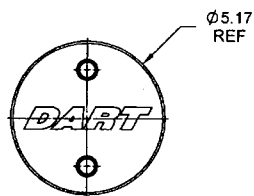
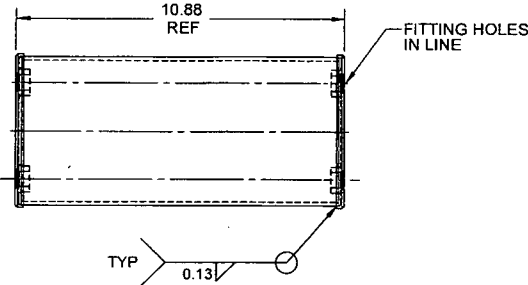
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74724 M.L.J
11/10/05



D3262-041 CANISTER ASSEMBLY

RELEASED
2010-05-07
N/A

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3262-041" AND B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 2.51 lbs
 - 8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3262-041	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-3	CAP

E	0.25 WAS 0.45 (ZNC7-4, C7-5); 0.13 WAS 0.33 (ZN B7-4, B7-5); ADD DIMENSION (ZN B1-4, D1-5, B1-5)	RF	10.05.03
D	ADD D3262-043/-5 (ZN B5-2; B5-5); REVISE DIMENSIONS TO EQUAL TOOL DIMENSIONS (ZN B2-4; C2-4) PER CAR 09-004	RF	09.12.30
C	Ø5.165 WAS Ø5.190	RF	06.08.31
B	ADD PRESSURE TESTING OPTION	MB	05.02.14
A	NEW ISSUE	RF	04.05.06
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	10.05.03		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3262	REV. E
TITLE FUEL PURGE CANISTER	SHEET 1 OF 5
SCALE NTS	
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

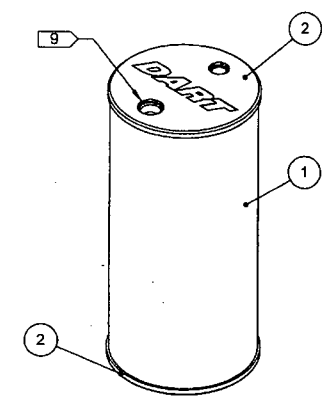
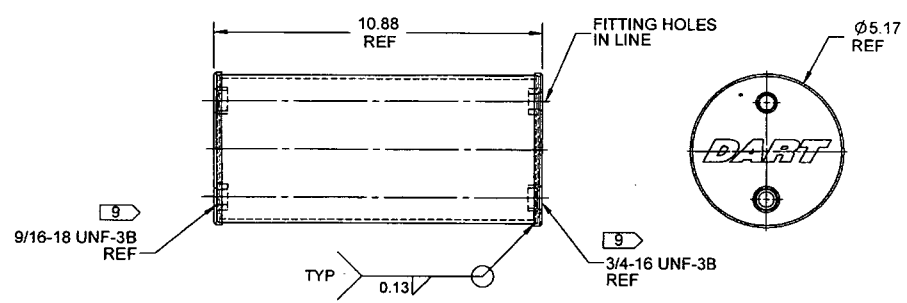
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

74724

ITEM	QTY -043	P/N	DESCRIPTION
	X	D3262-043	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-5	CAP



D3262-043 CANISTER ASSEMBLY

RELEASED
2010-05-07
AM

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3262-043" AND B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 2.50 lbs
 - 8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
 - 9) WELD CAPS WITH 3/4-16 TAP TOP HOLE IN LINE WITH 9/16-18 TAP BOTTOM HOLE

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3262	REV. E
MFG. APPR.	<i>[Signature]</i>		SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FUEL PURGE CANISTER	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

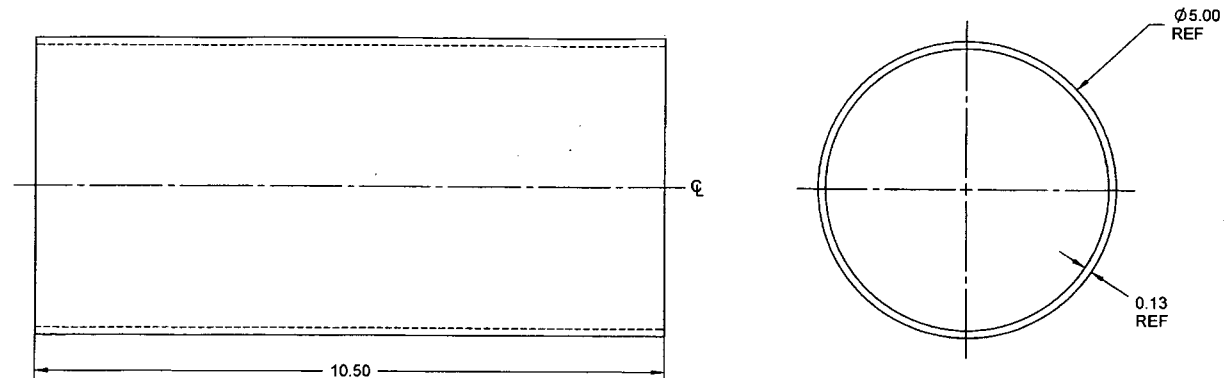
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

74724

**D3262-1 TUBE****RELEASED**
2010-05-07
JW**NOTES:**

1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, 5.00 OD x 0.125 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
REF. DART SPEC. M6061T6T5.000W.125

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 1.96 lbs

8) PART IS SYMMETRICAL ABOUT CENTERLINE

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D3262	REV. E
MFG. APPR.	RF		SHEET 3 OF 5
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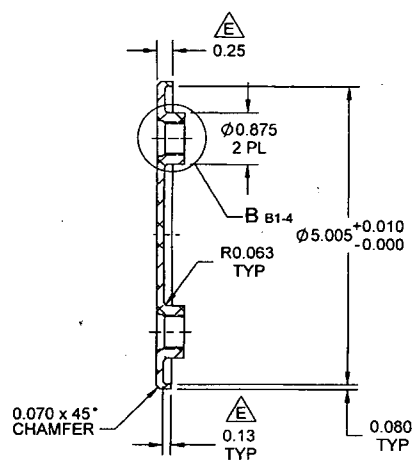
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

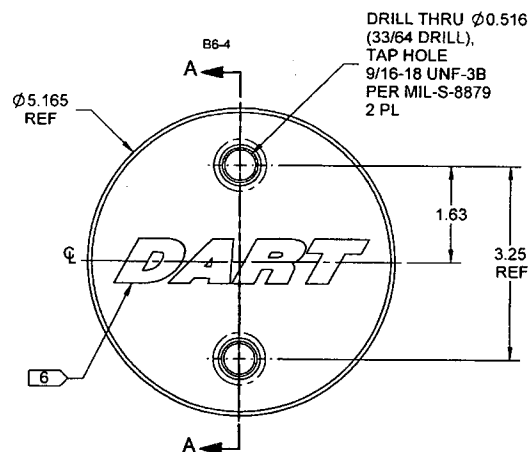
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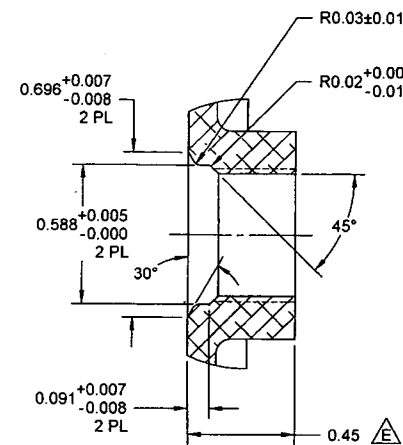
74724



SECTION A-A C5-4



D3262-3 CAP



DETAIL B C7-4
SCALE 2X

NOTES:

- 1) MATERIAL: 6061-T6/T651 ALUMINUM BAR
PER QQ-A-200/8 OR QQ-A-225/8
REF. DART SPEC. M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP
(MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN
- 7) WEIGHT: 0.28 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

RELEASED
2010-05-07

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	RF	D3262	SHEET 4 OF 5
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	FUEL PURGE CANISTER	
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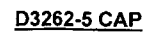
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MFG. APPR.	<i>RF</i>	D3262	SHEET 5 OF 5
APPROVED	<i>RF</i>	TITLE	SCALE
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